

Date:  
User:Monday, 26/05/2008 9:54:29 AM  
Julie Lecocq

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SHORT STEP ASSEMBLY HIGH SKID RH
Job Number	: 39478 -1	Part Number	: D350591214
Estimate Number	: 10720	Drawing Number	: D3078 REV A
P.O. Number	:	Project Number	: N/A
This Issue	: 26/05/2008 S.O. No. :	Drawing Revision	: A
Prsht Rev.	: NC	Material	:
First Issue	: / /	Due Date	: 10/06/2008
Previous Run	: 39165	Type	: LARGE FAB ASSY
Written By	:	Qty:	10 Um: Each
Checked & Approved By	: <u>JLD 08.5.23</u>		
Comment	Est Rev:B 05.10.14 Modified step 10 KJ/EC Est Rev:C 06-06-19 Added D2732-030 AS PER DSI9294 JLM Est Rev:C 06-06-27 Revised as per DSI9340 JLM		

## Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

1.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile and type labels as per PPP D350-591-214 CHG002

SAD 08/08/01

2.0

D2622120C

Step Extrusion



Comment: Qty.: 0.5000 Each(s)/Unit Total: 5.0000 Each(s)

Pick:

Qty Part Number

Description Batch

.5 D2622-120

Extrusion 39316

SAD 08/10/24

(10)

3.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut D2622-120 extrusion to 59.75" long as per Dwg D3078

2-Drill extrusion as per Dwg D3078 using Jig DT8680 for rivets. SP 08-07-28 (10)

3-Deburr

SAD 08/07/24

(10)

4.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SAD 08/07/24 (10)

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SHORT STEP ASSEMBLY HIGH SKID RH

Job Number: 39478

Part Number: D350591214

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D30671

End Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D3067-1

End Plate

B38926 ✓

SP. 08-07-31 (2x)

6.0

D30631

Support



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D3063-1

Support

B351091 ✓

SP. 08-07-31 (2x)

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Bevel end for welding FWD ONLY

2-Weld Support using Jig DT8681, weld Fwd End Plate as per QSI 004 & Dwg D3078

A/R Aluminum Rod

M106834  
M107678

3-Grind End Plate flush

SP. 08-07-31 (5x)

8.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

AD 08-07-30 (2)

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/07/31 (x2) (2x)

10.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

SAN 08/07/31 (2)



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Drawing Name: SHORT STEP ASSEMBLY HIGH SKID RH

Job Number: 39478

Part Number: D350591214

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



(2x)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M-A

08/07/31

12.0

D3065041

Step Leg Assembly HI



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D3065-041

Step Leg Assy

B38650

SAD

08/07/31

(x2)

13.0

D30661

Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D3066-1

Spacer

B39261

SAD

08/07/31

(x2)

14.0

MS20600AD4W4

Rivets



Comment: Qty.: 16.0000 Each(s)/Unit Total : 160.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

16 MS20600AD4W4

Rivet

M108077

SAD

08/07/31

(x2)

15.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Rivet Leg Assembly as per Dwg D3078.

SAD

08/07/31

(x2)

16.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SAD

08/07/31

(x2) RH

17.0

D30671

End Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D3067-1

End Plate

B38926

SP

08-07-31

(2x)

## Process Sheet

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Drawing Name: SHORT STEP ASSEMBLY HIGH SKID RH

Job Number: 39478

Part Number: D350591214

Job Number:



Seq. #:

Machine Or Operation:

Description :

18.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Bevel Aft end for welding

2-Inspect for foreign object as per QSI 024

3-Weld Aft End Plate as per QSI 004 & Dwg D3078

A/R Aluminum Rod M 106834

4-Grind End Plate flush

SAD 08/07/31 SP 08-07-31 (2X)

19.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

08-01-31 (2)

20.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/07/31 (2) 2RH

21.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Touch Up Chemical conversion

FL 08/07/31 (2)

22.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME: 6:30

OVEN TEMPERATURE: 320°

FINISH TIME: 7:00

FL 08/08/01 (2)

23.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk as per Dwg D3078 and QSI 005 4.4

FL 08/08/01 (2)



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Job Number: 39478

Part Number: D350591214

Job Number:



Seq. #:

Machine Or Operation:

Description :

24.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: Inspect Powder Coat and Wing Walk

*See 108/10/17224*

25.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

26.0

D22303

Lug



Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 D2230-3

Clamp *B39404*

*SEP*

27.0

D22301

Lug



Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 D2230-1

Clamp *B39315*

*SEP*

28.0

D2732

Rubber Extrusion



Comment: Qty.: 1.0000 f(s)/Unit Total : 10.0000 f(s)

Rubber Extrusion

4 X 3"

Batch: *B37632*

*SEP*

29.0

D2856400

Abrasion Strip



Comment: Qty.: 0.6000 f(s)/Unit Total : 6.0000 f(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 D2856-400(7.2") Abrasion Strip

*B37667*

*8/8/1*

*SEP*

# Process Sheet

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Drawing Name: SHORT STEP ASSEMBLY HIGH SKID RH

Job Number: 39478

Part Number: D350591214

Job Number:



Seq. #: Machine Or Operation:

Description :

30.0 AN335A Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 AN3-35A Bolt

M106993

scf

31.0 AN411A Bolt



Comment: Qty.: 6.0000 Each(s)/Unit Total : 60.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

6 AN4-11A Bolt

M106605

scf

32.0 AN413A Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 40.0000 Each(s)

Bolt

Batch:

M107989

scf

33.0 AN960JD10 Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 40.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

4 AN960JD10 Washer

M108558

scf

34.0 AN960JD416 Washer



Comment: Qty.: 12.0000 Each(s)/Unit Total : 120.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

12 AN960JD416 Washer

M108161

scf

35.0 MS21042L3 Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 MS21042L3 Nut (or -3)

M107665

2

scf

8/8/1

scf



## Process Sheet

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Drawing Name: SHORT STEP ASSEMBLY HIGH SKID RH

Job Number: 39478

Part Number: D350591214

Job Number:



Seq. #:

Machine Or Operation:

Description :

36.0

MS21042L4

Nut



2 ~~8x~~

Comment: Qty.: 6.0000 Each(s)/Unit Total : 60.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

6 MS21042L4

Nut (or -4)

M106478

8/8/1

50

37.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



5 08/08/01 ~~2~~

Comment: INSPECT 100% KITS FOR COMPLETENESS

38.0

PACKAGING 1

PACKAGING RESOURCE #1



2x1

Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D350-591-214

Location: D

PPP Rev: D

8/8/1

50

39.0

QC21

FINAL INSPECTION/W/O RELEASE



08/08/01 ~~2~~

Comment: FINAL INSPECTION/W/O RELEASE

Completion



MF 08-08-01



RELEASED  
02.09.20

DESIGN CP	DRAWN BY CP	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3078	REV. A SHEET 1 OF 2
DATE 02.09.11		TITLE STEP ASSEMBLY, HI SHORT SCALE NTS	
A	02.09.11	NEW ISSUE	

Part No.	Description	QTY -041	QTY -042
D3078-041	Step Assembly, High Short (LH)	X	
D3078-042	Step Assembly, High Short (RH)		X
D2622-60	STEP EXTRUSION	1	1
D3063-1	SUPPORT	1	1
D3065-041	LEG ASSEMBLY	1	1
D3066-1	SPACER	2	2
D3067-1	END PLATE	2	2
MS20600AD4W4	RIVET	16	16

**GENERAL NOTES:**

- 1) -041 SHOWN, FOR -042 INSTALL D3063-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

SHOP COPY  
RETURN TO  
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UNCONTROLLED COPY  
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WITHOUT NOTICE  
WORK ORDER  
NO. 39478

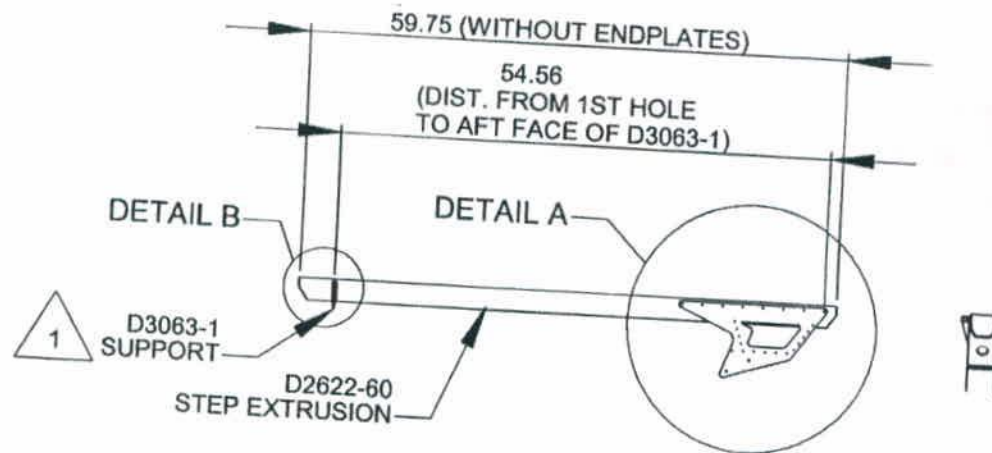
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**DART**

DESIGN	D	DRAWN BY	D	<b>DART AEROSPACE LTD</b>
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA
DATE	02.09.11	TITLE	D3078	REV. A
			STEP ASSEMBLY, HI SHORT	SHEET 2 OF 2
				SCALE 1:20

**RELEASED**  
02.03.2004

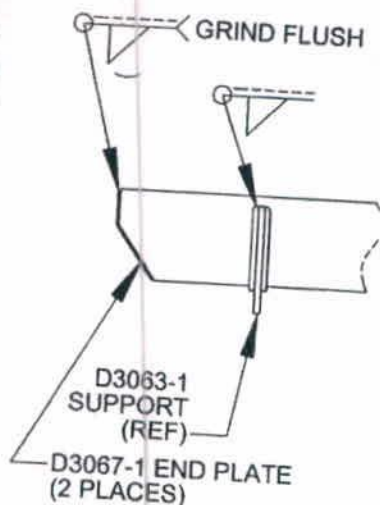
APPLY BLACK ANTI-SKID ON TOP SURFACE TO BOTTOM OF TOP RADIUS

DRILL  $\phi 0.128$  (#30) ON BOTH SIDES OF D2622 EXTRUSION TO MATCH D3065-041 HOLE PATTERN. RIVET D3065-041 TO D2622 USING MS20600AD4W4 RIVET (16 PLACES)

D3066-1 SPACER  
(2 PLACES)

D3065-041  
LEG ASSEMBLY

DETAIL A (1:5)



DETAIL B (1:5)

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